

Work Order ID 130432-2

130432

March-11-15 9:25:19 AM

Page 1

Item ID: D3153-12-09

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Panel, Beige

Stop *NS2*

Start Date: 3/11/15 Start Qty: 2.00

Required Date: 3/31/15 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3153	Rev B								

100 PURCHASING 0.00

100

Purchasing

Purchasing

Memo

Issue P/O:

Fabricate D3153-12-09 as per Dwg D3153

Possible Supplier: Delastek

Certificate of Conformity & Process sheet are required

0.00

110

Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

0.00

W 15-03-11

1x 15-04-1

Work Order ID 130432

March-11-15 9:25:19 AM

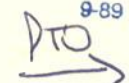
130432

Page 2

Item ID: D3153-12-09 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Panel, Beige
 Start Date: 3/11/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 3/31/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: 	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

① 1503-13 DAS
9
9-89


APR 16 2015 DAS
06
9-89

MLJ 15-01-16

 4-16

DQA:

Date: 15/05/11



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 15/05/11

Work Order update only ☐

Work Order: 130432	DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. D3153-12-09	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
NCR No. 15-4822	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☒	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☒	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material	15-04-13	100	①	Kydex 6185 .125" wall was used instead of Kydex 100 .093" wall	DAS 12 9-89 15/4/15	use Kydex 6185 * see attache email Acceptable per attached D.S. email	DAS 12 9-89 15/4/15	PD 15-04-15	PD 1504-15
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved	☒			EC no material in stock					

FAULT CATEGORY

Landing Gear		General					
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions	☐ Pressure/Forced			
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Set-up			
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect	☐ Temperature/Cure			
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing	☐ Weld			
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved	☐ Wrong Stock Pulled			
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong				
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge	☒ Other			
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread					
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set					
☐ Turning Sequence	☐ Finish	☐ Out of Calibration					
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence					

Picklist Print

Page 1

March-11-15 9:25:19 AM

Work Order ID: 130432

130432

Parent Item: D3153-12-09

D3153-12-09

Parent Item Name: Panel, Beige

Start Date: 3/11/15

Required Date: 3/31/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.07.11 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3153-12		Manufactured	No				Each	0.0000		2			

D3153-12

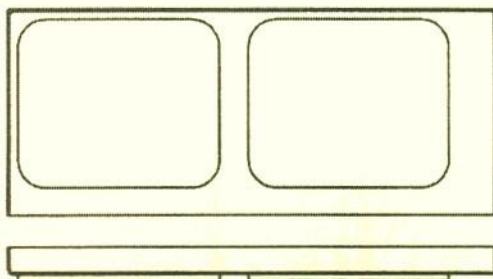
Panels

**

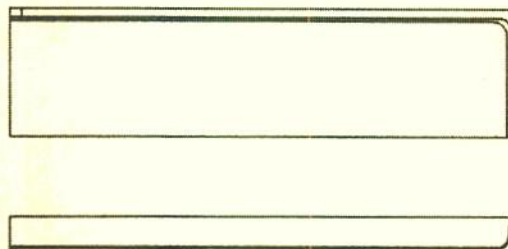
1X SP15-04-1

DART

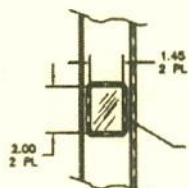
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3153	REV. B SHEET 1 OF 1
DATE 05.06.09		TITLE PANEL	SCALE NTS
A	02.04.24	NEW ISSUE	
B	05.06.09	D3153-13/-15 VIEW CORRECTION	



D3153-11-XX PANEL (SHOWN)
D3153-12-XX PANEL (OPPOSITE)

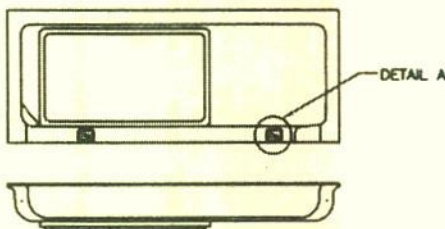


D3153-13-XX PANEL (SHOWN)
D3153-14-XX PANEL (OPPOSITE)

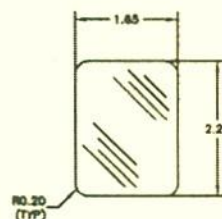


D3119-3 WINDOW (1)
INSTALL WITH 3M 3549B/A
ADHESIVE (A/R)
(2 PLACES)

DETAIL A



D3153-15-XX PANEL (SHOWN)
D3153-16-XX PANEL (OPPOSITE)



D3119-3 WINDOW
(FOR REFERENCE)

NOTES:

- 1) MATERIAL: KYDEX 100, 0.093" THICK
- 2) MAKE PARTS PER MOLD; AND REPLACE PREMIER P/N:

P/N	MOLD	REPLACES PREMIER P/N
D3153-11-XX	B56-43000-11T	B56-43000-11
D3153-12-XX	B56-43000-12T	B56-43000-12
D3153-13-XX	B56-43000-13T	B56-43000-13
D3153-14-XX	B56-43000-14T	B56-43000-14
D3153-15-XX	B56-43000-15T	B56-43000-15
D3153-16-XX	B56-43000-16T	B56-43000-16
- 3) COLOR PER CUSTOMER SPECIFICATION (-XX):

DASH No.	PART NO.	COLOR	VENDOR
-01	52000	CALCUTTA BLACK	KYDEX
-03	52001	PEWTER GRAY	
-05	52114	BLACK	
-07	62033	MONTEREY	
-09	72005	BEDGE	

EXAMPLE: D3153-11 IN CALCUTTA BLACK KYDEX = D3153-11-01

- 4) D3119-3
MATERIAL: LEXAN, 0.060 THICK

RELEASED
05-06-16

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Linda Lacelle

From: David Shepherd
Sent: March-18-15 12:52 PM
To: Linda Lacelle; Chris Provencal
Subject: RE: D3153 VIP panel

Linda,

Based on how thin those VIP trim panels get when we form them, I think it would be better to try the 0.125" thick sheet rather than the 0.080" thick sheet.

Regards,
David

From: Linda Lacelle
Sent: March-18-15 7:13 AM
To: David Shepherd; Chris Provencal
Subject: RE: D3153 VIP panel

Oh, and the .125 sheet is too damn short!

From: Linda Lacelle
Sent: March-18-15 9:07 AM
To: David Shepherd; Chris Provencal
Subject: FW: D3153 VIP panel
Importance: High

Bill Bury just came to see me, and we only have .080 and .125 in the Kydex 6185 (sigh) The D3153-12 calls up Kydex 100, .093"..
Can we use either of the .080 or .125 for this order??

L

From: Linda Lacelle
Sent: March-18-15 8:09 AM
To: Melody Shapcott (MShapcott@delastek.com)
Cc: 'Jocelyne Laurin' (jlaurin@delastek.com); David Shepherd

Subject: FW: D3153 VIP panel
Importance: High

Melody,

As requested, we authorize Delastek to use Kydex 6185 on our PO27735, for qty 2 x D3153-12. We will supply the material and have it delivered to your facility.

Thank you,

Linda

From: David Shepherd
Sent: March-15-15 11:42 PM
To: Linda Lacelle; Chris Provencal
Cc: Nigel Forbes; Sian Willems
Subject: RE: D3153 VIP panel

Linda,

Agree with Daryl ... I don't see a problem using any of Kydex 6185 materials that we already certified for other products.

Regards,
David

From: Linda Lacelle
Sent: March-13-15 8:36 AM
To: David Shepherd; Chris Provencal
Cc: Nigel Forbes; Sian Willems
Subject: RE: D3153 VIP panel

Or, as Daryl stated, use the Kydex6185. The customer is painting the panels anyway

L

From: Linda Lacelle
Sent: March-13-15 10:28 AM
To: David Shepherd; Chris Provencal
Cc: Nigel Forbes; Sian Willems
Subject: D3153 VIP panel
Importance: High

David/Chris,

BHT requires 2 x D3153-12-09 panels asap, but we received a L/T of mid-May from Delastek. We were thinking of bringing the mold back here and thermoforming them in house. I can't find any Kydex 100 as stated on the drwg, but there is an equivalent, can we use this? If we can, perhaps Delastek can also get it done faster...

Please advise asap

Thx

Linda

From: Dixon, Wade L (SABIC Innovative Plastics) [<mailto:wade.dixon@sabic-ip.com>]

Sent: March-13-15 9:56 AM

To: Linda Lacelle

Subject: RE: help

Linda

No Kydex 100 anywhere but have the Boltaron equivalent (see attached)

Boltaron 4330-3530-019

0.093 48x96

HC Beige

\$195.78 per sheet

Plus freight

Wade

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]

Sent: Friday, March 13, 2015 8:30 AM

To: Dixon, Wade L (SABIC Innovative Plastics)

Subject: help

Importance: High

Hi Wade,

I need a couple of sheets of Kydex 100, .093 – 72005 beige...can you help??

Linda Lacelle

Production manager

DART AEROSPACE

T 1-613-632-5200 Ext: 235

Linda Lacelle

From: Melody Shapcott <MShapcott@delastek.com>
Sent: March-17-15 3:11 PM
To: Linda Lacelle; Jocelyne Laurin
Subject: RE: CONFIRMATION ORDER po27735

Hello Linda,

I have discussed with my production team.

We can use your Kydex 6185 but we need a letter attesting that Dart authorizes us to use this type of Kydex for PO: po27735.

We need this delivered ASAP, if you could deliver it for Friday we'd appreciate.

As soon as we will receive your Kydex than we can start producing it on our side.

Let me know what's your status on your side and a waybill # so we track the Kydex.

Thank you,

Melody Shapcott

Gestionnaire de comptes

DELASTEK Inc.

2699, 5e Avenue, Local 14

Grand-Mère, Québec

G9T 2P7

Tel : 819-533-5788 #235

Fax : 819-533-3494

mshapcott@delastek.com

46.8

B/N

2 sheets
45 x 85

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The drawings, specifications, descriptions and other technical data attached are confidential and property of Delastek Inc. If you have received this transmission in error, please delete it from your system and notify the sender. Thank you.

Devez-vous vraiment imprimer ce courriel ? Pensons à l'environnement ! / Please consider the environment before printing this email

De : Linda Lacelle [<mailto:llacelle@dartaero.com>]

Envoyé : 17 mars 2015 12:00

À : Melody Shapcott; Jocelyne Laurin

Objet : RE: CONFIRMATION ORDER po27735

Importance : Haute

Hello again,

If you cannot provide us with a fast leadtime, we can go pick up the mold at your facility and produce the 2 parts here. Please advise asap, as customer is still waiting for a response.

Linda

From: Linda Lacelle

Sent: March-17-15 8:41 AM

To: 'Melody Shapcott'; 'Jocelyne Laurin'

Subject: RE: CONFIRMATION ORDER po27735

Importance: High

Any news on this please??

From: Linda Lacelle

Sent: March-16-15 8:53 AM

To: 'Melody Shapcott'; Jocelyne Laurin

Subject: RE: CONFIRMATION ORDER po27735

If we can change the material to kydex 6185 (which we have in stk), what is the best date you can do please?

Linda

From: Melody Shapcott [<mailto:MShapcott@delastek.com>]

Sent: March-16-15 8:52 AM

To: Linda Lacelle; Jocelyne Laurin

Subject: RE: CONFIRMATION ORDER po27735

Hello Linda,

For the moment this is our best date, we have to wait on the reception of the raw material.

I will let you know in 4 weeks if we can improve our date.

Thank you,

Melody Shapcott

Gestionnaire de comptes

DELASTEK Inc.

2699, 5e Avenue, Local 14
Grand-Mère, Québec
G9T 2P7
Tel : 819-533-5788 #235
Fax : 819-533-3494
mshapcott@delastek.com

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Devez-vous vraiment imprimer ce courriel ? Pensons à l'environnement ! / Please consider the environment before printing this email

De : Linda Lacelle [<mailto:llacelle@dartaero.com>]

Envoyé : 16 mars 2015 08:48

À : Jocelyne Laurin; Melody Shapcott

Objet : RE: CONFIRMATION ORDER po27735

Importance : Haute

Any update on this please?

From: Linda Lacelle

Sent: March-13-15 8:30 AM

To: 'Jocelyne Laurin'

Cc: Melody Shapcott (MShapcott@delastek.com)

Subject: RE: CONFIRMATION ORDER po27735

Importance: High

Any news on this please???

From: Linda Lacelle

Sent: March-12-15 9:59 AM

To: 'Jocelyne Laurin'

Cc: Melody Shapcott (MShapcott@delastek.com)

Subject: RE: CONFIRMATION ORDER po27735

Importance: High

Thanks Jocelyne, is there any way to improve this lead time? This is the same customer that took the last few panels. Please let me know what you can do.

Thx

Linda

From: Jocelyne Laurin [<mailto:JLaurin@delastek.com>]
Sent: March-11-15 4:44 PM
To: Linda Lacelle
Subject: CONFIRMATION ORDER po27735

Thank you

Jocelyne Laurin

Agente Service à la clientèle
Customer Service Agent

Delastek Inc.

2699, 5^e Avenue, local 14
Grand-Mère, Qc G9T 2P7
819-533-5788, poste 221
jlaurin@delastek.com

De : info@delastek.com [<mailto:info@delastek.com>]
Envoyé : 11 mars 2015 16:42
À : Jocelyne Laurin
Objet : Attached Image

Linda Lacelle

From: David Shepherd
Sent: March-15-15 11:42 PM
To: Linda Lacelle; Chris Provencal
Cc: Nigel Forbes; Sian Willems
Subject: RE: D3153 VIP panel

Linda,

Agree with Daryl ... I don't see a problem using any of Kydex 6185 materials that we already certified for other products.

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Sent: March-13-15 10:28 AM
To: David Shepherd; Chris Provencal
Cc: Nigel Forbes; Sian Willems
Subject: D3153 VIP panel
Importance: High

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Please advise asap

Thx

Handwritten signature and date:
2/25/16

Linda

From: Dixon, Wade L (SABIC Innovative Plastics) [<mailto:wade.dixon@sabic-ip.com>]

Sent: March-13-15 9:56 AM

To: Linda Lacelle

Subject: RE: help

Linda

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Boltaron 4330-3530-019

0.093 48x96

HC Beige

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Sent: Friday, March 13, 2015 8:30 AM

To: Dixon, Wade L (SABIC Innovative Plastics)

Subject: help

Importance: High

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I need a couple of sheets of Kydex 100, .093 – 72005 beige...can you help??

Linda Lacelle

Production manager

DART AEROSPACE

T 1-613-632-5200 Ext: 235



Surface Textures of KYDEX® Thermoplastic Sheet

For information applicable to KYDEX® FST please refer to 300 series technical briefs.

TB - 105

Introduction

KYDEX, LLC offers eight different textures ranging from high-gloss smooth to leatherette. Each texture presents its own unique opportunities and challenges. Textures are embossed into the sheet during the extrusion process, so available embossings may be limited based on KYDEX® sheet grade, thickness, or width. Talk with your KYDEX® thermoplastic sheet representative for more details. The following is a summary of each texture.

Standard KYDEX® Sheet Textures



P-1 Haircell

- Best abrasion resistance
- Excellent for high abuse areas
- Can tend to have higher metamerism in highly chromatic colours
- Common texture available for many years



P-3 Velour Matte

- Excellent abrasion resistance
- Easy to control gloss when formed
- Most widely specified texture for aircraft components
- Remains very "matte" if formed properly and most looks like a painted composite panel



P-8 Suede

- Good abrasion resistance but can show marring in light colours
- Excellent for textured female molding
- Great for flat laminations but can "gloss up" when vacuum formed



P-A Smooth

- Polished, high gloss appearance
- Prone to scratching
- Cannot be produced in low smoke formulations



P-C Level Haircell

- Leatherette appearance
- Good scratch resistance
- Common for high abuse areas
- Easy to control gloss level when thermoforming

SEKISUI SPI

ISO 9001 and 14001 Certified

Customer Service

6685 Low St, Bloomsburg, PA 17815 USA
Phone: 800.325.3133, +1.570.389.5810
Outside the US: +1.570.389.5814
Fax: 800.452.0155, +1.570.387.7786
Email: info@sekisui-spi.com

Technical Service

Phone: 800.682.8758
Fax: +1.570.387.8722
Outside the US: +1.570.387.6997
techservice@sekisui-spi.com

sekisui-spi.com

Surface Textures of KYDEX® Thermoplastic Sheet

For information applicable to KYDEX® FST please refer to 300 series technical briefs.

TB - 105

Standard KYDEX® Sheet Textures



P-E Smooth Nap

- Similar characteristics to P-8 Suede texture
- Slightly more embossing compared to P-8 Suede texture



P-H Seville

- Leather/cowhide grain type texture
- Not recommended for deep draw parts due to texture stretch
- Often used against similarly grained leathers



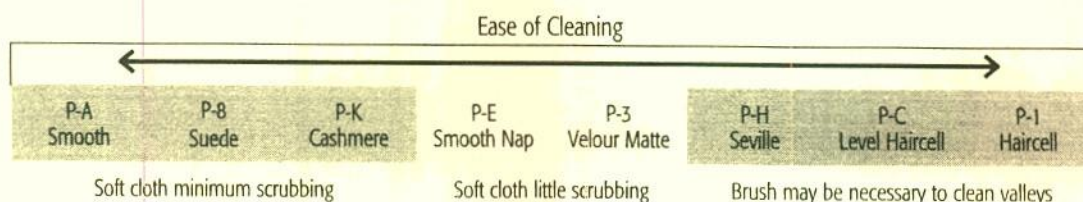
P-K Cashmere

- High abrasion resistance
- Excellent for flat lamination or shallow draw components
- Not recommended for deep draw or tight radii due to glossing

Texture Characteristics

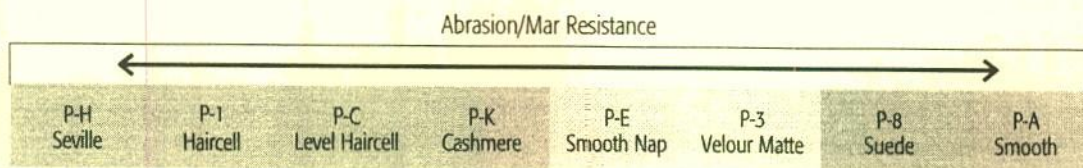
Cleaning

KYDEX® sheet has excellent chemical resistance and is easily cleaned with many common household cleaners such as fantastik® and Formula 409®. The texture of KYDEX® sheet plays a major role in the ease of cleaning. Shallow textured sheet can easily be cleaned with a soft cloth, while a heavier texture may require use of a scrub brush to remove material from texture valleys. For more information on cleaning of KYDEX® sheet, please refer to Technical Brief 160-A - Cleaning KYDEX® Sheet, and Technical Brief 160-B - Cleaning and Maintaining KYDEX® 510, on our website at www.sekisui-spi.com.



Abrasion/Mar Resistance

KYDEX® sheet is commonly used in high abuse applications, where it is important that the appearance of the sheet is maintained throughout the life of the material. Many of the standard textures have been developed to offer high levels of abrasion and mar resistance, providing not only superior durability but also lasting appearance.



SEKISUI SPI

ISO 9001 and 14001 Certified

Customer Service

6685 Low St, Bloomsburg, PA 17815 USA
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techservice@sekisui-spi.com

sekisui-spi.com

Surface Textures of KYDEX® Thermoplastic Sheet

For information applicable to KYDEX® FST please refer to 300 series technical briefs.

TB - 105

Texture Characteristics

Tooling Marks

Texture rolls are produced through an engraving process that uses a machining tool to cut the texture into the face of a cylinder roll. This tool has a specific width, which machines multiple sections across the width of the cylinder roll. Points on the engraved cylinder where the tooling sections meet have a faint transition line. These lines leave a faint impression in the sheet surface and are more noticeable in darker coloured sheet. Textures that have tooling marks include P-1 Haircell, P-8 Suede, P-C Level Haircell, P-E Smooth Nap, and P-H Seville. P-3 Velour Matte, P-K Cashmere and P-A Smooth are non-directional patterns that do not show tooling marks from the engraving process.

Gloss Level

The gloss level of KYDEX® sheet is determined by the process rolls used to texture the sheet. Most texturing rolls produce a low gloss appearance, with the exception of P-A Smooth, which has a higher gloss due to its polished surface. If necessary, a higher gloss can be achieved by adjusting the process conditions of the texturing rolls in all textures except P-H Seville. The level of gloss achievable will be limited according to the process capabilities of each texturing roll. In addition, in achieving a higher gloss level, the texture of the sheet will be less defined and will have a washed out appearance.

SEKISUI SPI

ISO 9001 and 14001 Certified

Customer Service

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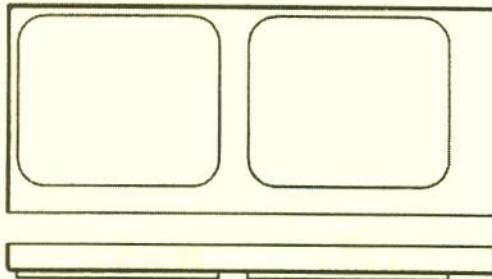
sekisui-spi.com

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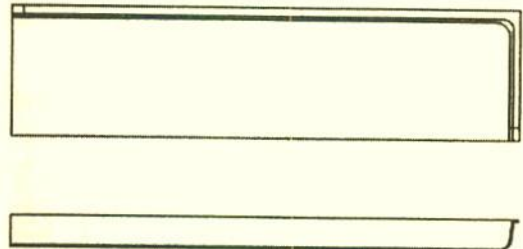
This information supersedes all previously published data.



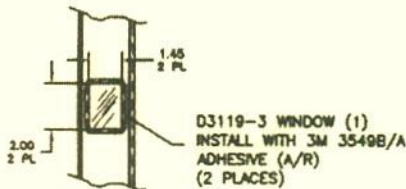
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3153	REV. B SHEET 1 OF 1
DATE 05.06.09		TITLE PANEL	SCALE NTS
A	02.04.24	NEW ISSUE	
B	05.06.09	D3153-13/-15 VIEW CORRECTION	



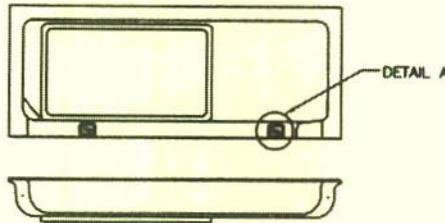
D3153-11-XX PANEL (SHOWN)
D3153-12-XX PANEL (OPPOSITE)



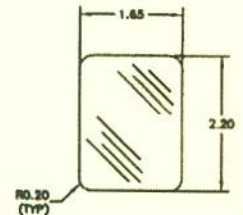
D3153-13-XX PANEL (SHOWN)
D3153-14-XX PANEL (OPPOSITE)



DETAIL A



D3153-15-XX PANEL (SHOWN)
D3153-16-XX PANEL (OPPOSITE)



D3119-3 WINDOW
(FOR REFERENCE)

NOTES:

- 1) MATERIAL: KYDEX 100, 0.093" THICK
- 2) MAKE PARTS PER MOLD; AND REPLACE PREMIER P/N:

P/N	MOLD	REPLACES PREMIER P/N
D3153-11-XX	B56-43000-11T	B56-43000-11
D3153-12-XX	B56-43000-12T	B56-43000-12
D3153-13-XX	B56-43000-13T	B56-43000-13
D3153-14-XX	B56-43000-14T	B56-43000-14
D3153-15-XX	B56-43000-15T	B56-43000-15
D3153-16-XX	B56-43000-16T	B56-43000-16
- 3) COLOR PER CUSTOMER SPECIFICATION (-XX):

DASH No.	PART NO.	COLOR	VENDOR
-01	52000	CALCUTTA BLACK	KYDEX
-03	52001	PEWTER GRAY	
-05	52114	BLACK	
-07	62033	MONTEREY	
-09	72005	BEIGE	

RELEASED
05-06-16

EXAMPLE: D3153-11 IN CALCUTTA BLACK KYDEX = D3153-11-01

- 4) D3119-3
MATERIAL: LEXAN, 0.060 THICK

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Linda Lacelle

From: Dixon, Wade L (SABIC Innovative Plastics) <wade.dixon@sabic-ip.com>
Sent: March-13-15 9:56 AM
To: Linda Lacelle
Subject: RE: help
Attachments: Aircraft-Reference-Chart.pdf

Linda

No Kydex 100 anywhere but have the Boltaron equivalent (see attached)

Boltaron 4330-3530-019
0.093 48x96
HC Beige
\$195.78 per sheet
Plus freight

Wade

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: Friday, March 13, 2015 8:30 AM
To: Dixon, Wade L (SABIC Innovative Plastics)
Subject: help
Importance: High

Hi Wade,
I need a couple of sheets of Kydex 100, .093 – 72005 beige...can you help??

Linda Lacelle
Production manager

DART AEROSPACE
T 1-613-632-5200 Ext: 235



Boltaron-Kydex *Aircraft Cross Reference Chart*

COMPETITIVE PRODUCT CROSS REFERENCE

BOLTARON	KYDEX
Boltaron 4205	Kydex 6185
Boltaron 4330	Kydex 100
Boltaron 4330M	Kydex 110
Boltaron 4800	Kydex 6200
Boltaron 6530	Kydex 430
Boltaron 6540	Kydex 430
Boltaron 9200/9200C	Kydex 6185
Boltaron 9230/9230C	Kydex 6185
Boltaron 9250/9250C	Kydex 6185
Boltaron 9815	Kydex 6565
Boltaron 9815D	Kydex 6565D
Boltaron 9815E	Kydex 6565
Boltaron 9815F	Kydex 6565
Boltaron 9815M	Kydex 6565D
Boltaron 9815P	Kydex 6565
Boltaron 9915FSTH	Kydex FST

BOLTARON

One General Street
Newcomerstown, Ohio 43832 USA

1 800 342 7444

info@boltaron.com
www.boltaron.com



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO27735

Purchase Order Date 3/11/15

PO Print Date 3/11/15

Page Number 1 of 2

Order From :
DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 819 533 5788

Ship To Contact
Ship To Phone
Ship Via: FedEx Overnight collect
Ship Acct:

Buyer Linda Lacelle
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3153-12 per drwg D3153 Rev. B CERTIFICATE OF CONFORMITY AND PROCESS SHEETS REQ'D PLEASE RUSH - REQ'D ASAP !	Panels	3/31/15 Yes 3/31/15	FN	2.00 Each	\$685.00	\$1,370.00
						Line Total:	\$1,370.00
2	71401-45 Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A041 quality management A042 dart noyification by supplier A043 retention of quality documents	PROCUREMENT QUALITY CLAUSE	3/31/15 No 3/31/15		1.00	\$0.00	\$0.00

Note:

3/11/15



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	59729
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-5200
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
31-03-2015	11-03-2015	25626	Linda Lacelle	PO277735	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
Fedex Int. Eco. Coll.		Point de départ		Melody Shapcott, ext. 235	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
✓ 2	1	1	DKC134-0038	Line #1 Panel N°D3153-12-09 RH U of M: Chaque DWG D3153 REV. B MATERIAL KYDEX .093 BEIGE (72005) CERTIFICATE OF CONFORMITY AND PROCESS SHEETS REQ'T DOCUMENT INCLUS Lot # 68022 1	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by:

Quality department

AO-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Lundi, 2015-03-16 11:56:01
Utilisateur: marc dubé

Feuille de Procédé

Client : DART US DART AEROSPACE LTD
Numéro Job : 68022
Numéro Soumission : 6942
Numéro B.A. :
Cette fois : 2015-03-16 No. B.V. :
Prsht Rev. : NC
Prem. fois : - - Type :
Job précédente : 63957Nom Dessin : PANEL
Numéro Article : DKC134-0038
Numéro Dessin : D3153
Projet Numéro : DK-359
Révision dessin : B
Matériel : Composites
Date Dûe : 2015-04-27 Qté: 2 Udm: UNITEÉcrit par :
Vérifié & Approuvé par :
Commentaires : N° de pièce Client: D3153-12-09

E.O.: N/A

Feuille de procédé Rév.: 00 création du premier

Formulaire d'inspection : INDK134-0038

Produit additionnel

Numéro Job:



Séq.: Machine ou Opération: Des

1.0 AMB0590 Kydex 100 cream 0.093"thick # 72005

Commentair Qty.: 1.00 FEUILLE(s)/Unit Total: 2.00 FEUILLE(s)
Kydex 100 cream 0.093"thick # 72005 N° de Lot:

2.0 SÉCHAGE/ ANEAL Séchage / Anéaling



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire sécher le plastique selon IG 0089 (PTN #25)

N° de Cuisson: 9102

Date: 25-3-15 Sceau: [Signature]

3.0 THERMOFORMAGE Thermoformage / Découpe primaire



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Monter le set-up du moule N° B56-43000-12T sur le thermoformeur 4' x 8' selon IG 0089.

Tailler le matériel aux dimensions requises: 45" x 85".

Thermoformer les pièces selon IG 0089 (Temp. 360-385°F).

Quantité: 1 Date: 25-3-15 Sceau: [Signature]

Kydex 6185

0.125"

Kydex 6185 Fourni
par Dart voir feuilles
attachées

15/03/18

Date: Lundi, 2015-03-16 11:56:01
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD		Nom Dessin: PANEL	
Numéro Job: 68022		Numéro Article: DKC134-0038	
Numéro Job: 			
# Séq.:	Machine ou Opération:	Description :	
4.0	DECOUPE	Découpe manuelle des pièces	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire la découpe primaire.			
Quantité: <u>1</u> Date: <u>27-3-15</u> Sceau: <u>SL</u>			
5.0	SÉCHAGE/ ANEAL	Séchage / Anéaling	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
SI APPLICABLE SEULEMENT, faire le traitement thermique (anéaling) selon IG 0089			
N° de Cuisson: _____			
Date: _____ Sceau: _____			
6.0	TRIMAGE	Trimage	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Trimer les pièces selon IF134-0023.			
Qté: <u>1</u> Date: <u>27-3-15</u> Sceau: <u>SL</u>			
7.0	IDENTIFICATION	Identification des pièces	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'identification selon IF134-0018.			
Qté: <u>1</u> Date: <u>31/3/15</u> Sceau: 			
8.0	INSPEC FINAL	Inspection finale	
			
Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs			
Faire l'inspection finale selon le INDK134-0038			
Qté: <u>1</u> Date: <u>31/03/15</u> Sceau: 			

Date: Lundi, 2015-03-16 11:56:01
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: PANEL

Numéro Job: 68022

Numéro Article: DKC134-0038

Numéro Job:



Séq.:

Machine ou Opération:

Description :

9.0

EMBAL / ENTREPO

Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage & l'entreposage selon IG 0057.

Qté: /

Date:

MAR 3 1 2015

Sceau:

14

